

# Work Order ID 65306

January 11, 2011 9:12:58 AM



Page 1

Item ID: D412-711-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Reference Door Assembly

Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CY

Date: 11/01/11

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



PURCHASING

Purchasing

Memo

13398

0.00

CY 11/01/11 D

Purchasing

Issue P/O: ~~13398~~ to Eagle Copters: "Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041" Send a copy of this IPP

110

0.00



Purchasing

Purchasing

Memo

0.00



FEB 18 2011

Purchasing

EAGLE: Pick Qty Part Number Description Batch: 1204-030-853-119LH Co-pilot Door 47418 Attach serviceable tags: 2-EAGLE Fabricate/Pick the following parts to go into the door in accordance with: D2046902 Sheet 1 Rev. 3: D2046902 Sheet 2 R

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Eagle- Send this W/O back to Dart Kit to be stocked at Eagle

Handwritten signature

FEB 18 2011

99

Document Control  
paperwork + labels

D412-711-011 011-02-22

**Work Order ID 65306**

January 11, 2011 9:12:59 AM

Page 2

Item ID: D412-711-041

Accept

Setup Start

Revision ID:

Item Name: Vertical Reference Door Assembly

Stop

Start Date: 1/11/11 Start Qty: 1.00

Required Date: 2/04/11 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

FEB 18 2011

140

Identify as per dwg &amp; Stock Location:

0.00



Packaging

Memo

0.00

Packaging

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

C21102/22

# Picklist Print

January 11, 2011 9:12:58 AM

Page 1

Work Order ID: 65306

Parent Item: D412-711-041

Parent Item Name: Vertical Reference Door Assembly



Start Date: 1/11/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A 104.08.18 New Issue: KJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-711-041P		Purchased	No			110	Each	0.0000	1	1			
Vertical Reference Door													
D412-711-101		Manufactured	No			120	Each	3.0000	1	1			
Replacement Bubble Window													

FEB 18 2011

FEB 18 2011

Location	Loc Qty	Loc Code
FG091	3	
61951	1	
63341	1	
63342	1	

# Eagle Copters Maintenance Ltd

## WORK REPORT

Work Order Number: 47418 V/Door

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Item: 1 L/H DOOR ASSEMBLY

Squawk: 1.1

Discrepancy:

Modify Door to Vertical  
Reference Door as per  
DART STC

Resolution:

L/H door modified to VRD  
as per Dart STC SH92-55  
on PO11-000092.  
Windows and latch  
assembly installed IAW  
STC SH92-55.

Vertical Reference Door  
modified as per DART  
instructions  
D20446901

2024-T3 .040 #1374,  
2024-T3 .080 #1325

1.1 Work Done By: Kelly Alliston

The maintenance described above has been performed in accordance with the applicable standards of airworthiness.

AMO 6-81 Signature: Craig Swayne on 2/18/2011

Parts:

Part Number	Description	Serial Number	Lot Number	Condition	Qty
D412-761-043	LATCH MECHANISM		LT-11-000907	New	1
D412-711-101	Replacement Vertical Reference Window		LT-11-000906	New	1
EA20469-16	PAD, ARM REST		LT-05-008249	New	1
110-070-41	SEAL		LT-10-012694	New	14
20-041-1	BUMPER		LT-10-014111	New	2
204-030-481-107	ROD ASSY		LT-11-000680	New	1
MS21059L3	NUTPLATE		LT-10-013608	New	4
MS21069L3	NUTPLATE		LT-10-013359	New	33
MS21071L3	NUTPLATE		LT-10-007614	New	4
MS21071L08	NUTPLATE		LT-09-008861	New	1
MS21069L08	NUTPLATE		LT-09-014484	New	8
204-031-762-001	SPRING ASSY		LT-10-009208.1	New	1
204-031-762-002	SPRING ASSY		LT-10-000529.2	New	1
20-041-1	BUMPER		LT-10-014111	New	2
204-030-499-005	ROLLER ASSY		LT-08-008488	New	1
MS27039-1-21	SCREW		LT-10-001780	New	1
MS24694S4	SCREW		LT-10-014414	New	10
MS20392-2C15	CLEVIS		LT-009550	New	1
MS24693S51	SCREW		LT-10-011450	New	10

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-125		L/H DOOR ASSEMBLY	Modify

\*\*\*\*\* Original Maintenance Releases and Independent Control Inspection details are stored electronically at \*\*\*\*\*

\*\*\*\*\* Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software \*\*\*\*\*

# Eagle Copters Maintenance Ltd

## WORK REPORT

Work Order Number: 47418 V/Door

*This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.*

**Squawk: 1.2**

Discrepancy:

Build Wiring Harness

Resolution:

Wiring Harness not required  
for this door

**1.2 Work Done By: Craig Swayne**

Parts:

Part Number	Description	Serial Number	Lot Number	Condition	Qty
-------------	-------------	---------------	------------	-----------	-----

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
-----	-------------	---------------	------------------	---------------------

**Squawk: 1.3**

Discrepancy:

Strip, prep and prime door  
and misc. parts as required

Resolution:

Door and misc. parts  
stripped, prep'd and primed  
as required.

**1.3 Work Done By: Colin Gould**

Parts:

Part Number	Description	Serial Number	Lot Number	Condition	Qty
-------------	-------------	---------------	------------	-----------	-----

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
-----	-------------	---------------	------------------	---------------------

\* End of Report \*

\*\*\*\*\* Original Maintenance Releases and Independent Control Inspection details are stored electronically at \*\*\*\*\*

\*\*\*\*\* Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software \*\*\*\*\*

# EAGLE COPTERS MAINTENANCE LTD.

823 McTAVISH ROAD N.E., CALGARY, ALBERTA T2E 7G9

D.O.T. APPROVAL No. 6-81

Nomenclature D412-711-04

Manufacturer BHT Type/Model

Part No. VR DOOR Serial No. N.S.N.

Total time: UNK Work Order 47418

T.S.O. N/A Overhaul ☐ NEW ☐

Inspected ☐ Tested ☐ Repair ☐ Modification ☒ Removal ☐

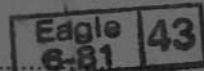
Previous Certification WOTF 47418

The maintenance described has been performed in accordance with the applicable standards of airworthiness.

FEB 18, 2011

DATE

NAME OR AUTHORIZED INSPECTOR



LIC. No. / STAMP

Details of outstanding work and other information on reverse.

MAI TENANCE RELEASE

REMARKS

(Details of work performed/reason for removal)

MODIFIED TO VRD AS PER  
DART STC SH92-55

(Additional work to be performed upon installation)

INSTALLED ON.....DATE.....

**Linda Lacelle**

---

**From:** Harvey Siemens <hsiemens@dartaero.com>  
**Sent:** February 17, 2011 4:03 PM  
**To:** L Lacelle  
**Subject:** 711 VR Door - Eagle PO 11-000327 and Dart PO 13253

Linda

Do you have the paperwork for this door? Can you email it to me? I guess Eagle has just about completed the door, if you could send me all the paperwork including the Red label then we can complete the door and get the info back to you.

Their customer guy is coming on Wednesday to review the aircraft so we need to be done our stuff before then.

Thanks

Regards,

*Harvey Siemens*  
Mechanical Designer  
DART Aerospace Ltd.

P: 403-717-0328  
F: 403-717-1288  
E: [hsiemens@dartaero.com](mailto:hsiemens@dartaero.com)  
W: [www.dartaero.com](http://www.dartaero.com)  
M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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**From:** Colin Gould [<mailto:cgould@eaglecopters.com>]  
**Sent:** February-17-11 9:30 AM  
**To:** 'Harvey Siemens'  
**Subject:** VR Door

Hey  
We need to complete the paper work for the VR door on WO 47418. Eagle's PO is 11-000327 and Darts PO is 13253.  
Thanks

Colin Gould  
Structures Manager  
Eagle Copters Maintenance Ltd  
[cgould@eaglecopters.com](mailto:cgould@eaglecopters.com)



# Work Order ID 65306

January 11, 2011 9:12:58 AM



Page 1

Item ID: D412-711-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Reference Door Assembly

Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CY

Date: 11/01/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



PURCHASING

Purchasing

Memo

13398

0.00

Purchasing

Issue P/O: 13353 to Eagle Copiers "Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041" Send a copy of this IPP

CY 11/01/11 ①

110

0.00



Purchasing

Purchasing

Memo

0.00

Purchasing

EAGLE: Pick Qty Part Number Description Batch: 1204-030-853-119LH Co-pilot Door 47418 Attach serviceable tags 2-EAGLE: Fabricate/Pick the following parts to go into the door in accordance with: D2046902 Sheet 1 Rev. 3C D2046902 Sheet 2 R



FEB 18 2011

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Eagle- Send this W/O back to DartKit to be stocked at Eagle

AS

FEB 18 2011

**Work Order ID 65306**

January 11, 2011 9:12:59 AM



Page 2

Item ID: D412-711-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Reference Door Assembly

Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

FEB 18 2011

140

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

# Picklist Print

Page 1

January 11, 2011 9:12:58 AM

Work Order ID: 65306

Parent Item: D412-711-041

Parent Item Name: Vertical Reference Door Assembly



Start Date: 1/11/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A1104.08.18 New Issue: IKJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-711-041P 		Purchased	No			110	Each	0.0000	1	1		FEB 18 2011	
Vertical Reference Door													
D412-711-101 		Manufactured	No			120	Each	3.0000	1	1		FEB 18 2011	
Replacement Bubble Window													

## Location

## Loc Qty

## Loc Code

FG091

3

61951

1

63341

1

63342

1

Work Order Number: 47418 V/Door

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Item: 1 L/H DOOR ASSEMBLY

**Squawk: 1.1****Discrepancy:**

Modify Door to Vertical  
Reference Door as per  
DART STC

**Resolution:**

L/H door modified to VRD  
as per Dart STC SH92-55  
on PO11-000092.  
Windows and latch  
assembly installed IAW  
STC SH92-55.

Vertical Reference Door  
modified as per DART  
instructions  
D20446901

2024-T3 .040 #1374,  
2024-T3 .080 #1325

1.1 Work Done By: Kelly Alliston

**The maintenance described above has been performed in accordance with the applicable standards of airworthiness.****AMO 6-81** Signature: Craig Swayne on 2/18/2011**Parts:**

Part Number	Description	Serial Number	Lot Number	Condition	Qty
D412-761-043	LATCH MECHANISM		LT-11-000907	New	1
D412-711-101	Replacement Vertical Reference Window		LT-11-000906	New	1
EA20469-16	PAD, ARM REST		LT-05-008249	New	1
110-070-41	SEAL		LT-10-012694	New	14
20-041-1	BUMPER		LT-10-014111	New	2
204-030-481-107	ROD ASSY		LT-11-000680	New	1
MS21059L3	NUTPLATE		LT-10-013608	New	4
MS21069L3	NUTPLATE		LT-10-013359	New	33
MS21071L3	NUTPLATE		LT-10-007614	New	4
MS21071L08	NUTPLATE		LT-09-008861	New	1
MS21069L08	NUTPLATE		LT-09-014484	New	8
204-031-762-001	SPRING ASSY		LT-10-009208.1	New	1
204-031-762-002	SPRING ASSY		LT-10-000529.2	New	1
20-041-1	BUMPER		LT-10-014111	New	2
204-030-499-005	ROLLER ASSY		LT-08-008488	New	1
MS27039-1-21	SCREW		LT-10-001780	New	1
MS24694S4	SCREW		LT-10-014414	New	10
MS20392-2C15	CLEVIS		LT-009550	New	1
MS24693S1	SCREW		LT-10-011450	New	10

**Outside Services:**

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-125		L/H DOOR ASSEMBLY	Modify

\*\*\*\*\* Original Maintenance Releases and Independent Control Inspection details are stored electronically at \*\*\*\*\*  
\*\*\*\*\* Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software \*\*\*\*\*

Work Order Number: 47418 V/Door

*This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.***Squawk: 1.2**Discrepancy:

Build Wiring Harness

Resolution:Wiring Harness not required  
for this door**1.2** Work Done By: Craig SwayneParts:

Part Number	Description	Serial Number	Lot Number	Condition	Qty
-------------	-------------	---------------	------------	-----------	-----

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
-----	-------------	---------------	------------------	---------------------

**Squawk: 1.3**Discrepancy:Strip, prep and prime door  
and misc. parts as requiredResolution:Door and misc. parts  
stripped, prep'd and primed  
as required.**1.3** Work Done By: Colin GouldParts:

Part Number	Description	Serial Number	Lot Number	Condition	Qty
-------------	-------------	---------------	------------	-----------	-----

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
-----	-------------	---------------	------------------	---------------------

\* End of Report \*

\*\*\*\*\* Original Maintenance Releases and Independent Control Inspection details are stored electronically at \*\*\*\*\*  
\*\*\*\*\* Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software \*\*\*\*\*

# EAGLE COPTERS MAINTENANCE LTD.

823 McTAVISH ROAD N.E., CALGARY, ALBERTA T2E 7G9

D.O.T. APPROVAL No. 6-81

Nomenclature D412-711-04

Manufacturer BHT Type/Model

Part No. VR DOOR Serial No. N.S.N.

Total time: UNK Work Order 47418

T.S.O. N/A Overhaul ☐ NEW ☐

Inspected ☐ Tested ☐ Repair ☐ Modification ☒ Removal ☐

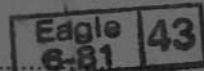
Previous Certification WOTF 47418

The maintenance described has been performed in accordance with the applicable standards of airworthiness.

FEB 18, 2011

DATE

NAME OR AUTHORIZED INSPECTOR



LIC. No. / STAMP

Details of outstanding work and other information on reverse.

MAI TENANCE RELEASE

REMARKS

(Details of work performed/reason for removal)

MODIFIED TO VRD AS PER  
DART STC SH92-55

(Additional work to be performed upon installation)

INSTALLED ON.....DATE.....

**Work Order ID 65306**

Page 1

January 11, 2011 9:12:58 AM

Item ID: D412-711-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Reference Door Assembly

Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CYDate: 11/01/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



PURCHASING

Purchasing

Memo

13398

0.00

Purchasing

Issue P/O: 13253 to Eagle Copters "Assembly of D412-711-041  
Door Assembly in accordance with Dart IPP D412-711-041" ☐ Send a copy of  
this IPP

CY 11/01/11 ①

110

0.00



Purchasing

Purchasing

Memo

0.00

Purchasing

EAGLE ☐ Pick: Qty Part Number Description Batch ☐ 1204-030-853-119LH Co-  
pilot Door ☐ Attach serviceable tags ☐ 2-EAGLE ☐ Fabricate/Pick  
the following parts to go into the door in accordance with: D2046902  
Sheet 1 Rev. 3 ☐ D2046902 Sheet 2 R

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Eagle- Send this W/O back to DartKit to be stocked at Eagle



**Work Order ID 65306**

Page 2

January 11, 2011 9:12:59 AM

Item ID: D412-711-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Reference Door Assembly

Start Date: 1/11/11 Start Qty: 1.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				_____	_____	_____	_____
140  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00  0.00				_____	_____	_____	_____
150  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				_____	_____	_____	_____

CL11102122

# Picklist Print

January 11, 2011 9:12:58 AM

Page 1

Work Order ID: 65306

Parent Item: D412-711-041

Parent Item Name: Vertical Reference Door Assembly



Start Date: 1/11/11

Required Date: 2/04/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 04.08.18 New Issue KJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-711-041P		Purchased	No			110	Each	0.0000	1	1			
Vertical Reference Door													
D412-711-101		Manufactured	No			120	Each	3.0000	1	1			
Replacement Bubble Window													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				FG091				3					
				61951				1					
				63341				1					
				63342				1					

CZ 11/02/22

Fagle